

Work Order ID 92932

November-12-12 3:30:39 PM

92932

Page 1

Item ID: 649.4815

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shim

Start Date: 12/11/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12-11-13*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

649.4800

A

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

2084.040

2-Debur if necessary

30 0 Jm 12-11-24

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

30 0 Jm 12-11-24

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Work Order ID 92932

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Page 2

Item ID: 649.4815

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 12/11/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

160

Outsource process-Anodize per QSI017 4.1.10.1

0.00

160

Outsource4

Memo

0.00

Outsource process - Anodize

ISSUE P/O: 18504
HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

170

Receive & Inspect for Damage & Mat'l Certs

0.00

170

Packaging

Memo

0.00

Packaging

30
can

PL 12-11-26

PL 12-11-26 (30)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY											
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Work Order ID 92932

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Page 3

Item ID: 649.4815

Accept

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Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 12/11/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

30

DAS
05 12-12-23
9-89

190

0.00

190

SprayPaint

Memo

0.00

Spray Painting

PRIME IAW MIL-P-23377J TYPE I CLASS N AS PER DWG. (SEE NOTE 2)

PRIMER BATCH: 123693

30

Ø

Ø

DAS
05 12-12-31
9-89

200

QC14- Inspect Spray Paint

0.00

200

QC

Memo

0.00

Quality Control

30

DAS
05 13-01-05
9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY											
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Work Order ID 92932

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92932

Page 4

Item ID: 649.4815

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 12/11/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

210

Identify as per dwg & Stock Location: 139H

0.00

210

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

(43/92) 80

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

13/1/10

MF

13-01-09

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY											
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Picklist Print

November-12-12 3:30:42 PM

Page 1

Work Order ID: 92932

Parent Item: 649.4815

Parent Item Name: Shim

92932

649 4815

Start Date: 12/11/2012

Required Date: 03/12/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			110	sf	195.4512	0.375	11.842 11			
									**	12.0			
<p>*M2024T3S 040*</p> <p>2024-T3 .040 sheet</p>													

Jm12-11-24

Location

Loc Qty

Loc Code

MAT022

195.4511626

120605

32.9127416

121197

32.498421

122136

17.39

123217

112.65

123217

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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MATR. A ALUM- NUM 2024 T3 PER AMS QQ-A 250/4

3. DEBURR AND BREAK ALL SHARP EDGES

4 IDENTIFY LAW MPP 120 LASER ETCH P/N AND REVISION 12PI CENTURY GOTHIC.

5 PART DIMENSIONS CONTROLLED BY CAD MODEL: FILE NAME: 649.4816 DOUBLR.SLDPRT

6 INSPECTION DIMENSIONS SHOWN WITH FINISH APPROX. 3-5 MIL MAX PER FACE.

SHC 1997, 47, 1.

References

ENGINEER . . .

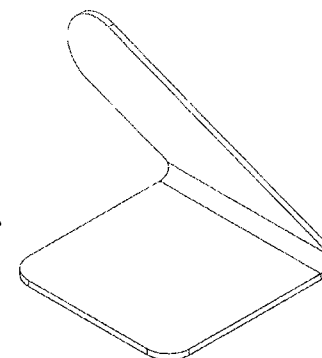
UNCONTROLLED.

SUBJECT TO

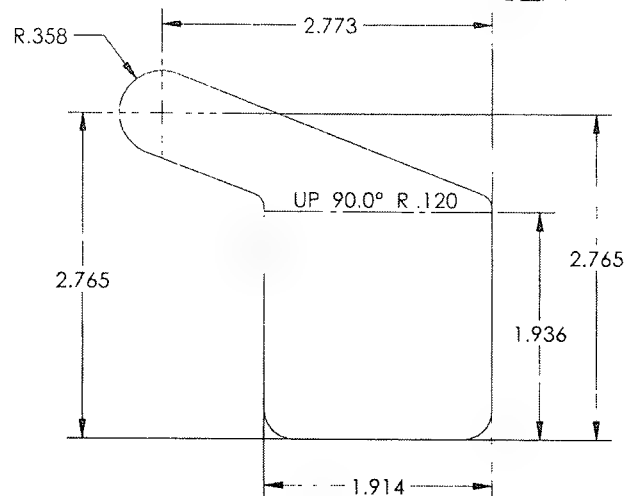
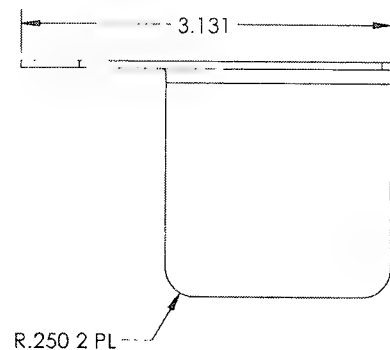
Will be . . .

WORKING

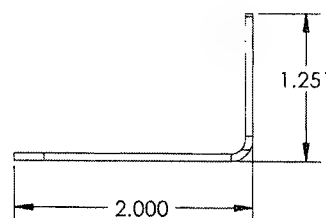
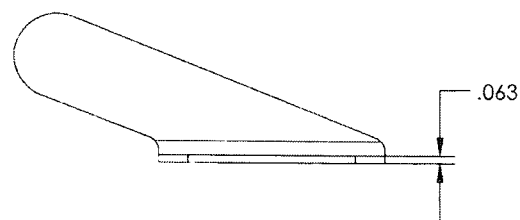
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12-11-13





















649.4811

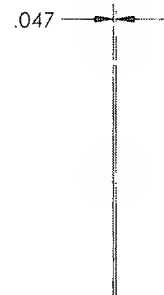
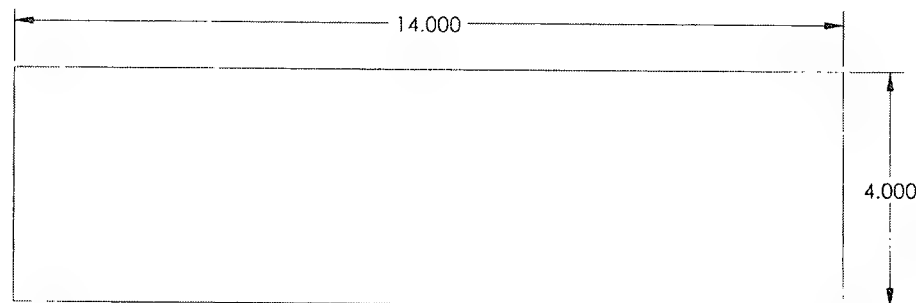


649.4811
FLAT PATTERN



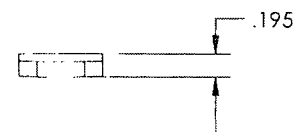
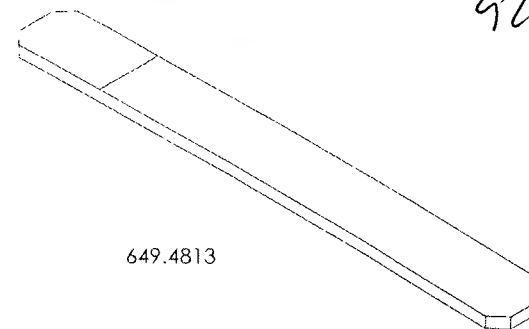
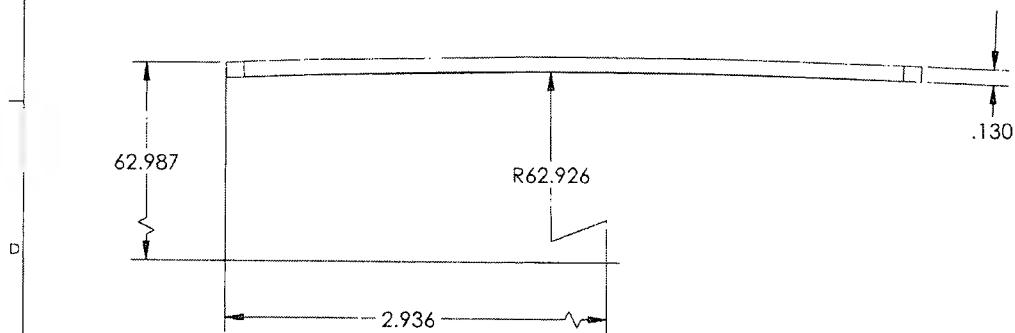
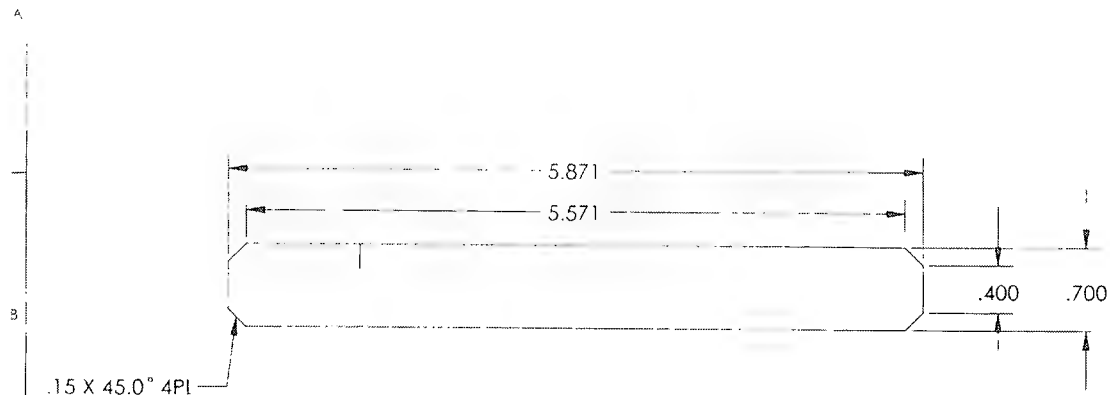
	7	649.4816	DOUBLER			
	6	649.4815	SHIM			
	5	649.4814	DOUBLER			
	4	649.4813	SHIM			
	3	649.4812	SHIM			
	2	649.4811	CLIP			
	1		DELETED			
	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	
QTY	PARTS LIST					
NEXT ASSY [S]	APICAL INDUSTRIES					
649.4700	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5313					
	ORIGINAL DATE 10-20-78	1 OF 11 DRAWN BY A. QUAN	1 OF 11 CHECKED BY P. EPAVO	SHEETMETAL		
	DRAWING APPROVAL P. BRAVO	11/25/81				
	CONTRACT NO.					
	JULIES SHIPMENT SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS UNLESS 3 PLACE DECIMALS UNLESS SPECIFIED		CASE CODE B 07M06	QTY NO. 649.4800	REV. A	
			SCALE NONE	SHEET 1	OF 5	

92932



648.4812

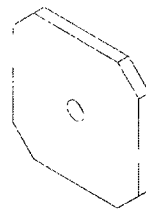
ORIGINAL DATE 11/22/11		APICAL INDUSTRIES	
DRAWN BY A. QUAY		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056 3512 (760) 724 5300	
CHECKED BY P. BRAVO		SHEETMETAL	
DRAWING APPROVAL P. BRAVO		SHEET CODE B 07/M26	
JOB NO. 648.4800		SHEET NO. 649.4800	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 3 PLACE DECIMALS ± .00 ANGLES ± .5°		REV A	
		SHEET 2 OF 5	



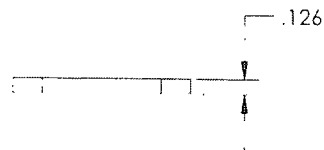
ORIGINAL DATE		2008.01	
DESIGNED BY	CHECKED		
P. CHAI	P. BRAYO		
DRAWING APPROVAL			
P. BRAYO			
DATE		2008.01	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS MILLIMETERS .0005 .001 .005 .010 .015 .020 .030 .040 .050 .060 .070 .080 .090 .100 .125 .150 .175 .200 .250 .300 .350 .400 .450 .500 .600 .700 .800 .900 1.000 1.250 1.500 1.750 2.000 2.500 3.000 3.500 4.000 4.500 5.000 6.000 7.000 8.000 9.000 10.000			
SIZE	CAGE CODE	QWG NO.	REV.
B	07M26	649.4800	A
SCALE: NONE			SHEET 3 OF 5

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724 5300

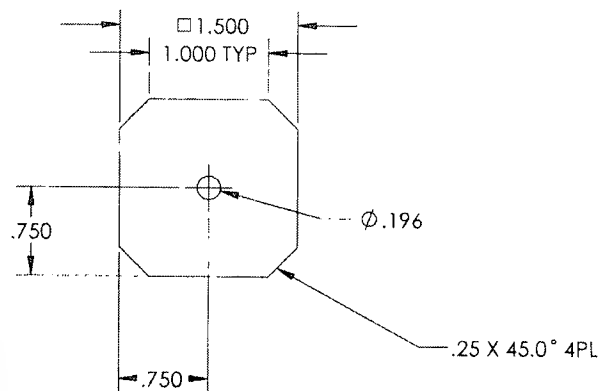
SHEETMETAL



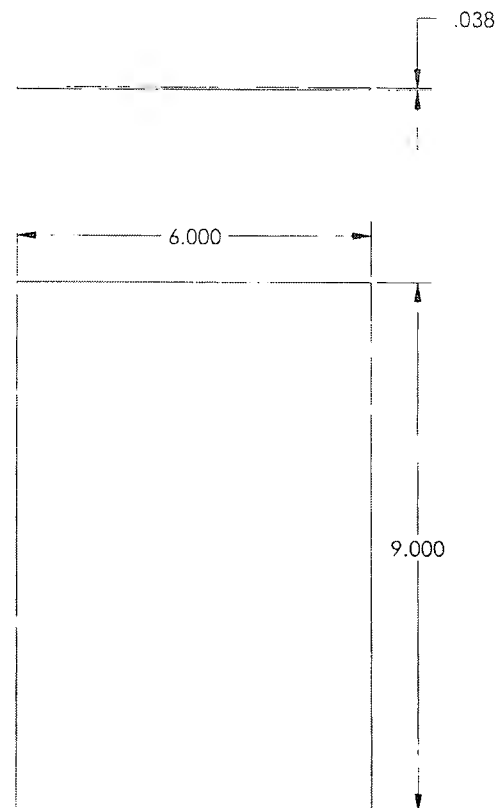
649.4814



.126



.25 X 45.0° 4PL

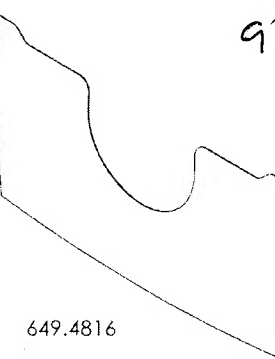
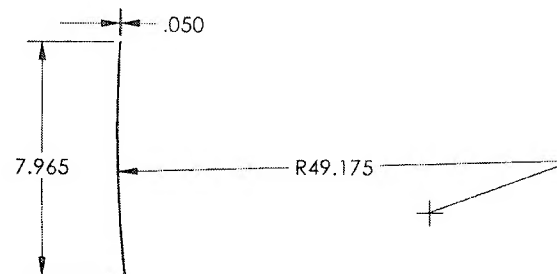
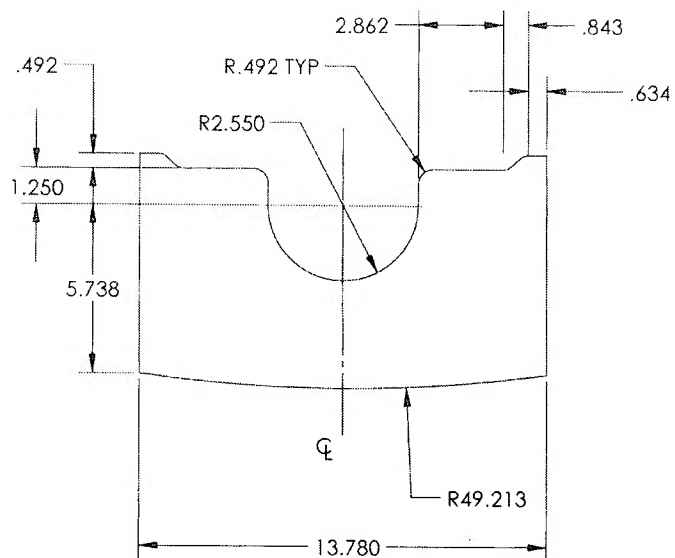


.038

649.4815

92932

ORIGINAL DATE 11/03/11		APICAL INDUSTRIES	
DRAWN BY A. QUAN		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY P. BRAVO		SHEETMETAL	
ENGINEER'S APPROVAL (SIGNATURE)		SCALE NONE	
C. CONTRACT NO.		SHEET 4 OF 5	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ± .01 ANGLES ± .5°		SEE CAD CODE B 07M16	QTY NO. 649.4800
		REV. A	



92932

649.4816

ORIGINAL DATE (DD/DA/YY)		11/03/11	
DRAWN BY A. QUAN		CHECKED BY P. BRAVO	
DRAWING APPROVAL P. BRAVO			
SCALE: NONE		SHEET 5 OF 5	

APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
SHEETMETAL	
REV. A	QTY. 100
DATE 07/24/11	DWG. NO. 649.4800



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62107

Date: 12-Dec-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms	Ship Via																																																								
<table border="1"><thead><tr><th>Quantity</th><th>Description</th></tr></thead><tbody><tr><td>1 lot</td><td>Part: ASST</td></tr><tr><td></td><td>8 PCS 647.1610</td></tr><tr><td></td><td>5 PCS 647.1612</td></tr><tr><td></td><td>2 PCS 647.1713</td></tr><tr><td></td><td>6 PCS 647.1811</td></tr><tr><td></td><td>1 PC 647.1816</td></tr><tr><td></td><td>1 PC 647.1817</td></tr><tr><td></td><td>8 PCS 647.1818</td></tr><tr><td></td><td>11 PCS 646.3210</td></tr><tr><td></td><td>20 PCS 646.3313</td></tr><tr><td></td><td>10 PCS 646.3717</td></tr><tr><td></td><td>20 PCS 646.3717</td></tr><tr><td></td><td>16 PCS 647.4610</td></tr><tr><td></td><td>10 PCS 649.4811</td></tr><tr><td></td><td>10 PCS 649.4812</td></tr><tr><td></td><td>24 PCS 649.4814</td></tr><tr><td></td><td>30 PCS 649.4815</td></tr><tr><td></td><td>6 PCS 647.7913</td></tr><tr><td></td><td>3 PCS 647.7919</td></tr><tr><td></td><td>10 PCS 647.9010</td></tr><tr><td></td><td>10 PCS 647.9011</td></tr><tr><td></td><td>15 PCS 647.9012</td></tr><tr><td></td><td>40 PCS 647.9013</td></tr><tr><td></td><td>60 PCS 646.9710</td></tr><tr><td></td><td>HARD ANODIZE BLACK</td></tr><tr><td></td><td>MIL-A-8625 TYPE III CLASS 2</td></tr><tr><td></td><td>Job: 20120768</td></tr></tbody></table>	Quantity	Description	1 lot	Part: ASST		8 PCS 647.1610		5 PCS 647.1612		2 PCS 647.1713		6 PCS 647.1811		1 PC 647.1816		1 PC 647.1817		8 PCS 647.1818		11 PCS 646.3210		20 PCS 646.3313		10 PCS 646.3717		20 PCS 646.3717		16 PCS 647.4610		10 PCS 649.4811		10 PCS 649.4812		24 PCS 649.4814		30 PCS 649.4815		6 PCS 647.7913		3 PCS 647.7919		10 PCS 647.9010		10 PCS 647.9011		15 PCS 647.9012		40 PCS 647.9013		60 PCS 646.9710		HARD ANODIZE BLACK		MIL-A-8625 TYPE III CLASS 2		Job: 20120768	Rev:
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Certificate of Conformance																																																									
A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.																																																									
ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY																																																									
DATE: 12/12/12																																																									

PO: PO18506

Line:



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Fax: 613-632-1185

Terms	Ship Via
Quantity	Description
	CERTIFIED SIGNATURE : <i>Mh</i>
	RECEIVER SIGNATURE : <i>R. J. [Signature]</i>